

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020020**Date Inspected:** 17-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** SHANGHAI CHINA**CWI Name:** Mr. Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG TRIAL ASSEMBLY**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

SEGMENT 12W:

Shielded Metal Arc (SMAW) welding of Weld Joint OBW12E-001(12BW+12CW, SP-SP,CW Side), And Welder is identified as 041713,044551,040611; ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of Weld Joint SEG3005K-090&SEG3006T-035(12BW+12CW,BP-LD Hold back,CB Side), And Welder is identified as 046704; ZPMC Quality Control (QC) is identified as Mr. Shi Lei . The welding variables appeared to comply with the Applicable WPS-B-P-2212-TC-U4b-FCM-1.

SMAW welding of Weld Joint SP3040-001-040(12BW+12CW,T Rib CJP,CB Side), And Welder is identified as 057333; ZPMC Quality Control (QC) is identified as Mr. Shi Lei . The welding variables appeared to comply with the Applicable WPS-B-P-2214-B-U2-FCM-1.

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SEGMENT12E:

SMAW welding of Weld Joint SEG3001X-051(12AE+12BE,BP-LD,BK Side), And Welding Repair Report(WR)B-WR20103,Welder is identified as 050289; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang . The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G(2F)-FCM-Repair-1.

SMAW welding of Weld Joint SP3018-001-039(12BE+12CE,T Rib CJP BK Side), And Welder is identified as 040320; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2114-B-U2-FCM-1.

SMAW welding of Weld Joint EP3005-001-013&014 (12BE+12CE, I Rib, Bk Side), And Welder is identified as 044515; ZPMC Quality Control (QC) is identified as Mr. Wang Li Yang. The welding variables appeared to comply with the Applicable WPS-B-T-2114-B-U2-FCM-1.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 08200.

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ABF Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as OBG 12AW+12BW Splice Weld &Temporary attachment removal area. The weld designations reviewed are as follows.

1. OBW12B-001
 2. OBW12D-002,003
- BAY #14:

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 08203.

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ABF Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as OBG 13CW Weld area. The weld designations reviewed are as follows.

1. FB3220-001- 059, 060, 071, 072, 074, 075, 078, 079, 085, 086.
2. SEG3015K-006, 269, 270,

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 08201.

WELDING INSPECTION REPORT

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Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ABF Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as OBG 13CW Weld area. The weld designations reviewed are as follows.

1. SEG3015N-021to 031.
2. LD3036-001-071, 072, 098, 099, 102~105, 131, 132,

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
